

Date: Monday, 3/6/2006 1:55:46 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RADIUS BLOCK
Job Number	: 26078		
Estimate Number	: 10822		
P.O. Number	: N/A	Part Number	: D2274
This Issue	: 3/6/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2274 REV F
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25769	Drawing Revision	: F
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/31/2006
Checked & Approved By	: <u>06.03.06</u>	Qty:	500 Um: Each
Comment	: Est. H 00.05.18 Added inspection level 8 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125"
-----	--------------------	--------------------------



Comment: Qty.: 0.0962 f(s)/Unit Total: 48.0900 f(s)  
6061-T6 Bar .75" x .125"

Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch

M13712 x 5  
M15919 x 23  
M17400 x 32

En 06/04/01

501

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR  
Shear blanks 9.00" long +/- 0.030"  
Note: 1 blank makes 9 pieces

En 06/04/01

501

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1  
Machine as per folio D2274

En 06/04/02

501

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 06/04/02

501

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 06/04/02

501

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: SD Date: 06/04/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/6/2006 1:55:46 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RADIUS BLOCK

Job Number: 26078

Part Number: D2274

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

Deburr any rough edges after tumbling

IBC 06-04-04 501

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

d.m 06-04-10 500

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jan 16

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST35

AP 06/04/13 499

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/17

Job Completion



06-04-17

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

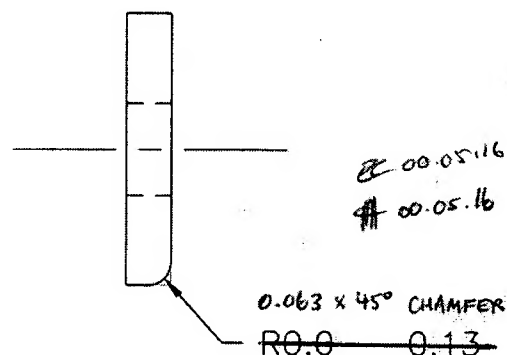
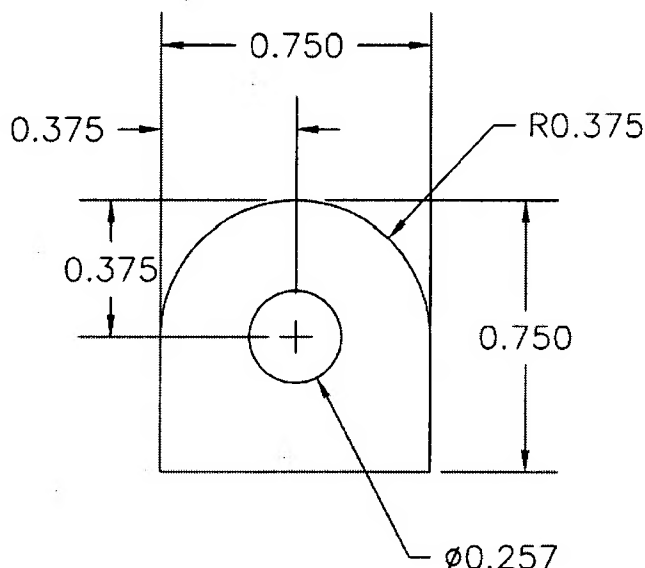
**NOTE:** Date & initial all entries





DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED  
98/08/18 KE



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK  
OR 6061-T6 (QQ-A-250/11) 0.125 THICK.  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26078